

Work Order ID: 67482

Tuesday, March 22, 2011 2:44:19 PM

PRELIMINARY ISSUE

PRELIMINARY
ISSUE

Page 1

Item ID: D4323-20

Accept

Revision ID: PRELIM

Item Name: Cabin Side Post, RH

Start Date: 3/22/2011 Start Qty: 1.00

Required Date: 3/23/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:



Approvals: Process Plan: 14 Date: 11/03/22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____ Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4323	PA1 <u>RAA</u>

100		0.00							
HandThermo	Memo	0.00							DR
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								11/05/22

105		0.00							
HandThermo	Memo	0.00							DR
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								11/03/22

Temp: 150° F
Time IN: 4:00 pm 11/03/21
Time OUT: 7:00 am 11/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4323-20

Accept



Setup Start



Revision ID: PRELIM

Item Name: Cabin Side Post, RH

Stop



Start Date: 3/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

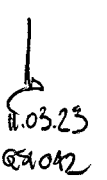
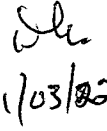


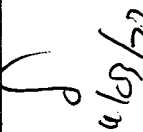


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA102 using tool DT9728 Dwg Rev: <u>PAS</u> Folio Rev: <u>A</u>	0.00 0.00				(x1)	(x1)		DL 11/03/22 ATO
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				(x1)			DL 11/03/22
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							Parts not trimes to be Done Q seal Do not ungle Dug Sul03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 4323-20 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>67482</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/22	110	Heavy Mould Marks Showing through this part.	 11.03.23 67482	Scrap 1 part. Re-sand mould & form 1 new part	 11/03/22	 11/03/23	 11.03.23	 11/03/23

NOTE: Date & initial all entries

Work Order ID 67482

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Item ID: D4323-20

Accept



Setup Start



Revision ID: PRELIM

Item Name: Cabin Side Post, RH

Stop



Start Date: 3/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

N/A

See attached

JL
11/03/23

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

h

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



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Item ID:	D4323-20	Accept		Setup	Start	
Revision ID:	PRELIM					
Item Name:	Cabin Side Post, RH				Stop	
Start Date:	3/22/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/23/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

AD2390

POSITIVE RECALL
EFFECTIVE 4/3/11 AUTH UA
RELEASED AM DATE 4/10/11

UUC0329

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 22, 2011 2:44:25 PM

Page 1

Work Order ID: 67482

Parent Item: D4323-20

Parent Item Name: Cabin Side Post, RH

Start Date: 3/22/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 11/03/22 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	948.0376	13.5416	14.25432			



6185 KYDEX .080"



Location

therm

Loc Qty

948.037564

81.189115

866.848449

Loc Code

109703

116576

28.5086 sq ft.

DL
11/03/22

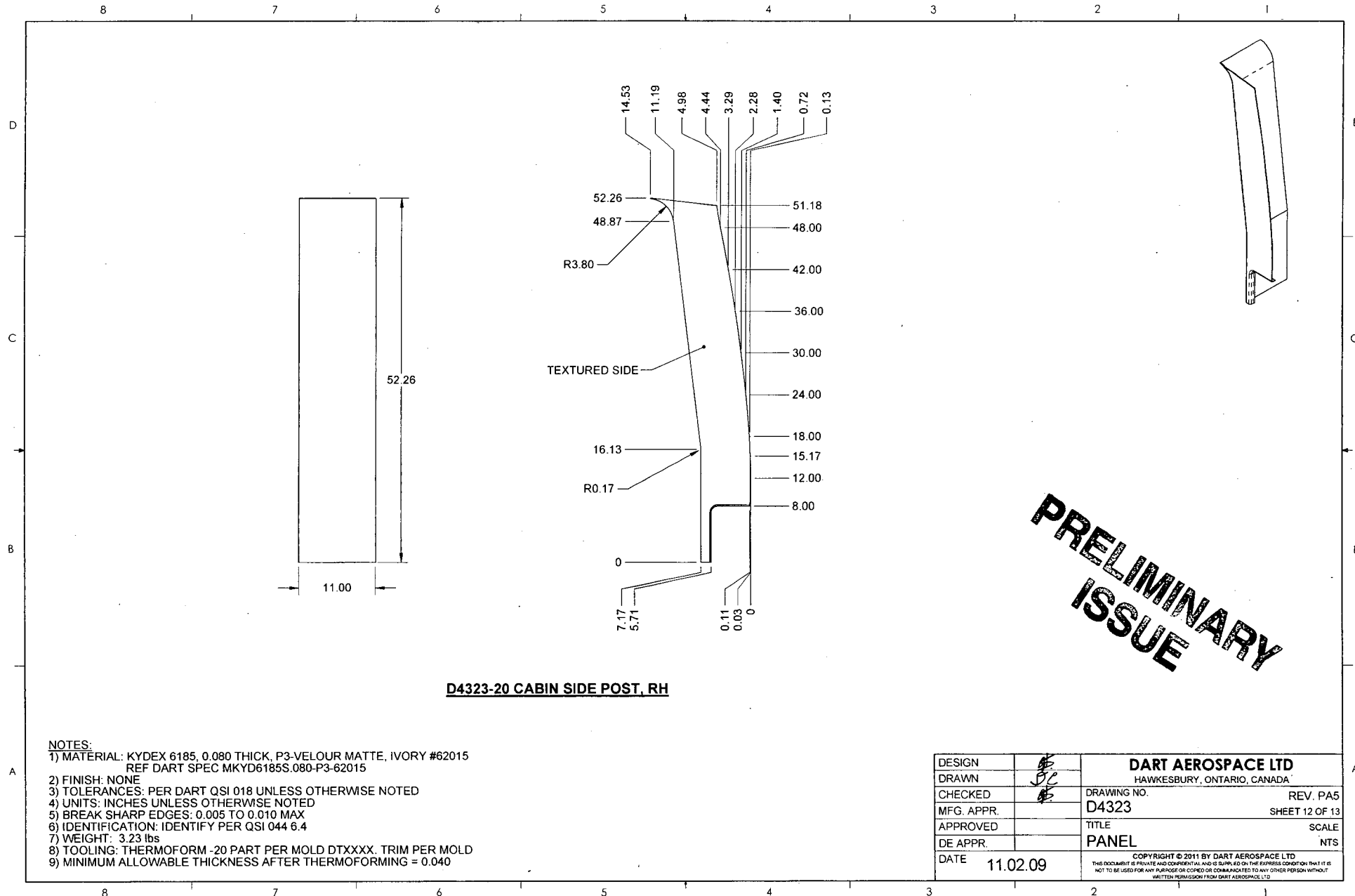
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

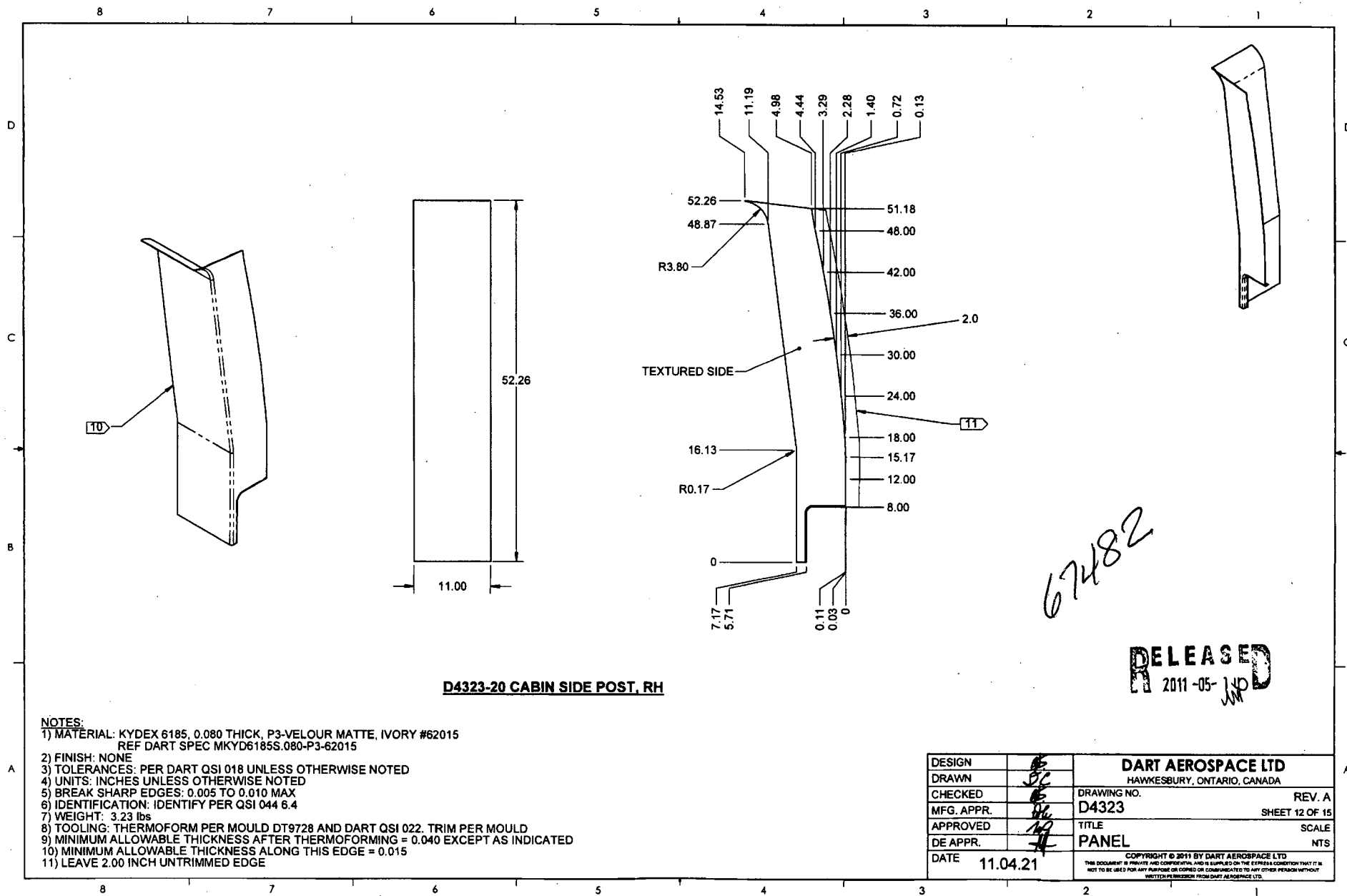
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NOTE: Date & initial all entries





Daryl Leger

From: Daryl Leger [dleger@dartaero.com]
Sent: Wednesday, March 23, 2011 10:15 AM
To: 'Daniel Campbell'
Cc: 'Harvey Siemens'; Linda Lacelle (llacelle@dartaero.com)
Subject: RE: D4323 Parts

Dan

I will do my best to ship the parts today.

Please note: If the parts are deemed acceptable, please notify the proper authority at Dart so that the positive recall can be removed on the Work Orders.

Daryl

From: Daniel Campbell [mailto:dcampbell@dartaero.com]
Sent: Wednesday, March 23, 2011 9:21 AM
To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

Hi Daryl,

As per our conversation this morning, you can release the D4323-1/-2/-19/-20 parts for shipping to YYC without having trimmed them first. This means that the dimensions will not match the drawings, but since these are essentially "prototype" parts, they will be trimmed to fit here in YYC. The drawings will be modified as per the final fitting and trimming.

Cheers.

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com

3/23/2011

Daryl Leger

From: Daniel Campbell [dcampbell@dartaero.com]
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To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

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Cheers.

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

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F: 403-717-1288
E: dcampbell@dartaero.com
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M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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3/23/2011